

Work Order ID 163122

Wednesday, June 21, 2017 3:36:01 PM

163122

Page 1

Item ID: D5350-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Adapter

Start Date: 7/3/2017 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 7/3/2017 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan:  Date: JUN 21 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5350	D

100		0.00							DAS 49 9-89
100						12	0		17/07/03
Bandsaw	Memo	0.60							
Jeaspa Bandsaw	CUT BLANK AT 3.600"								

110		0.00							DAS 08 9-89
110	CONVENTIONAL MILLING MACHINE					12	0		
HAAS 5AXIS	Memo	6.00							
HAAS CNC vertical machine #5	1-Machine per folio FB524 DWG REV: <u>D</u> FOLIO REV: <u>AA</u>								

2- Deburr and break all sharp edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

B. 17-07-04

120

QC

Memo

0.12

12 0 9-89

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.24

12 0 9-89

Quality Control

DAS
14
9-89

17/07/10

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.24

(X12) 0 2070710
BEB.

Hand Finishing

DQA: _____ Date: _____



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Approvals:

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Date: _____

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Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

141

QC7-Inspect Chemical Conversion Coat

0.00

141

QC

Memo

0.12

Quality Control

12 ϕ 17-07-14 DAS 34 9-89

150

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.84

Powder Coating

START TIME: 8:40

OVEN TEMPERATURE: 320-

FINISH TIME: 9:10

****MASK HOLES AS PER NOTE #8****

12 ϕ 17-07-14 DAS 34 9-89

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.12

Quality Control

12 ϕ 17-07-14 DAS 38 9-89

JUL 14 2017

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170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>51575</u> Memo	0.00 0.12				<u>12</u>	<u>JUL 18 2017</u>	<u>6</u>	<u>DAS 9-89</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.20						<u>17/7/18</u>	<u>9</u>

DAS
21
9-89

JUL 18 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

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163122

Parent Item: D5350-5

D5350-5

Parent Item Name: Adapter

Start Date: 7/3/2017

Required Date: 7/3/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 17-01-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	6.4000	0.3	3.789474			DAS 49 9-89

M6061T6B2 000X03 500

**

6061-T6 Bar 2.00 x 3.50

Location

Loc Qty

Loc Code

MAT004

6.4

m136036

6.4

3.708

17/07/03

DQA: _____ Date: _____

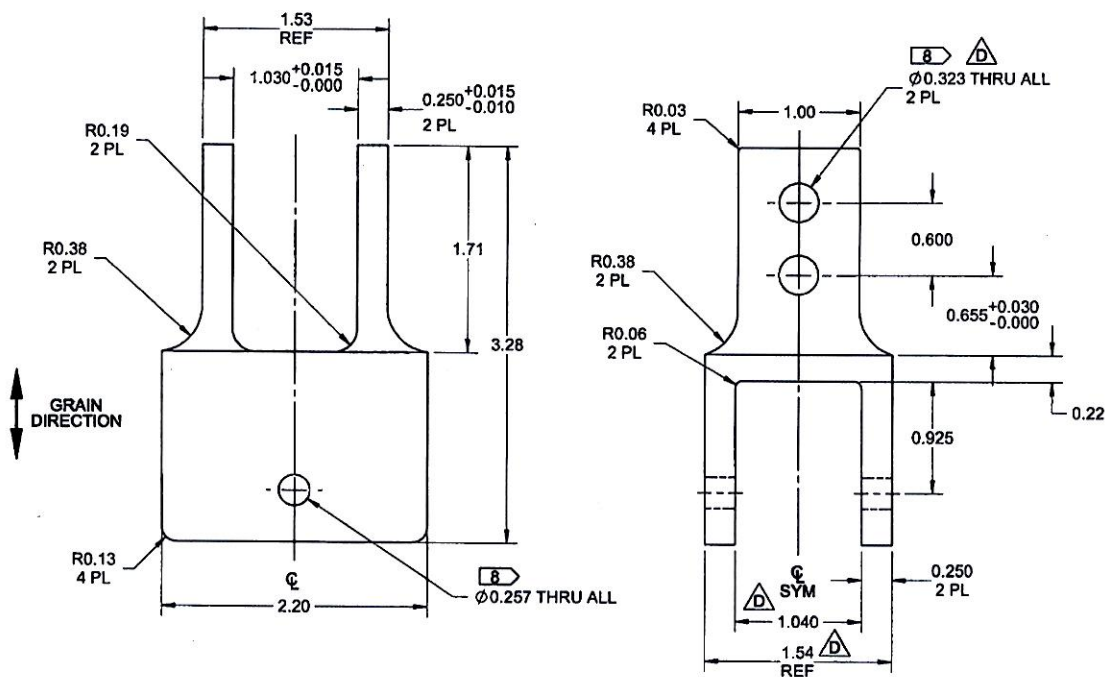
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D5350-5 ADAPTER Δ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163122

JUN 21 2017

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	JFS	D5350	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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